

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003250**Date Inspected:** 15-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** C.M. Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

This Caltrans QA Inspector has been assigned to the ZPMC, ABF, Caltrans group tagging team performing the review of numerous QC and QA documents for the purpose of continuing with the on-going group tagging of the segments identified below.

**South Fabrication Bay OBG Assemblies**

OBG Assembly Segment 3AE- Caltrans QA observed ZPMC is in the process of fitting 1 Longitudinal Diaphragms at the SSD17 Panel Point (PP) 21 location.

OBG Assembly Segment 3BE- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 4AE- Caltrans QA observed ZPMC depositing FCAW in the 4G position being deposited on CJP weld number 6 on Floor Beam FL 2-1 to FL 1-1 at location SSD 19 PP24 on the C5 side of Floor Beam. This weld is located on the top flange of the Floor Beam and designated weld number 006 and was welded by ZPMC welder Xu Li Guang. Caltrans QA observed ZPMC depositing FCAW in the 4G position being deposited on CJP weld number 127, on Floor Beam FL 2-1 to FL 1-1 at location SSD 19 PP24 on the C5 side of

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

Floor Beam. This weld is located on the lower flange of the Floor Beams and was also welded by ZPMC welder Xu Li Guang. Both welds utilized the following Welding Procedure Specification WPS-B-T-2231-B-U2-F-1. This QA inspector witnessed ZPMC's QC inspectors monitoring and recording weld parameters for the above mention items. See photograph for additional information and/or weld locations.

OBG Assembly Segment 4BE- Caltrans QA observed ZPMC UT technicians Eshui Qui, Xu Rong Gang and Ma Gi Long performing UT after repair on Seg. 20A weld number 019 and 025. These welds were found to be in noncompliance by ZPMC's UT technicians.

North Fabrication Bay OBG Assemblies

OBG Assembly Segment 5AW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 5BW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 5CW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 4BW- Caltrans QA observed ZPMC welders depositing SMAW filler metal on Seg. 19A Side panel E7 to bottom panel D6 on the "B" side of this segment. WPS-B-P-2214-B-U2-FCM was being utilized by ZPMC welders Li Zai Jun, Wang Jian, Zang Wei and Zang Yanbo on weld joints 019 and 025. This QA inspector witnessed ZPMC's QC inspectors monitoring and recording weld parameters for the above mention items.

OBG Assembly Segment 4AW- Caltrans QA observed ZPMC in the process of fitting PP24.

OBG Assembly Segment 3BW- Caltrans QA observed FCAW being deposited on the two welds (Number 017 and 018) attaching the Longitudinal Diaphragm (Number LD005-02) to Bottom Panel at the SSD13 - PP23 segment 15B location.

OBG Assembly Segment 3AW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



## Summary of Conversations:

Conversations are within the body of the report.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady, Velasco 13816942685, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	McClendon,Timothy	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

---